

Date: Monday, 25/05/2009 12:48:49 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 48195-2

Estimate Number : 11119

P.O. Number :

This Issue : 25/05/2009 S.O. No. :

Prsht Rev. : NC

First Issue : 11

Previous Run : 46614

Type : MACHINED PARTS

Drawing Name : CLAMP

Part Number : D30411

Drawing Number : D3041 REV.C

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 12/06/2009

Qty: 40 Um: Each

Written By :

Checked & Approved By :

Comment :

Est: A 01.07.11 New Issue SM
 est B 07.04.09 rev.c dwg EC

Additional Product

Job Number:

Seq. #: Machine Or Operation:

Description :

1.0 D2423

Lug Extrusion

Comment: Qty.: 0.0875 f(s)/Unit Total: 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: 043722

09/06/10

40

2.0 BAND SAW

BAND SAW

Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

09/06/10

40

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK

Comment: SECOND CHECK

40

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1.



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMD 09/06/22 (x40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

conts 2076/22 (x40)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

~~Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3~~

~~Mask inside of 0.8120" diameter hole~~

START TIME: 12:40pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:10pm

911 09-06-22 (x40)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ref 9/6/22 (40)

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description

1 D2611 Bearing

Batch

46841

Ref 9/6/22

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041 using DT9472

2- Stake bearing into place as per Dwg D3041 using DT9456

3- Touch up stake mark with white Imron paint using fine point paint brush.

SB 09/06/22 (5)

Monday, 25/05/2009 12:48:49 PM
Julie Dawson

Process Sheet

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Drawing Name: CLAMP

Job Number: 48195

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50966/23

(15)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

696/23 (15)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



C 209/06/24

DART AEROSPACE LTD		Work Order: 4825
Description: Clamp		Part Number: D3041-1
Inspection Dwg: D3041	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030	4.203	✓			
0.275	+/-0.010	0.275	✓			
R1.225	+/-0.010	1.225	✓			
0.400	+/-0.010	0.400	✓			
R0.250	+/-0.010	0.250	✓			
0.313	+/-0.010	0.314	✓			
R0.063	+/-0.010	0.063	✓			
1.19	+/-0.030	1.19	✓			
1.124	+/-0.010	1.129	✓			
0.563	+/-0.010	0.564	✓			
R0.562	+/-0.010	0.562	✓			
Ø0.8115 - 0.8110	N/A	0.811	✓			
2.071	+/-0.010	2.073	✓			
0.750	+/-0.010	0.750	✓			
0.375	+/-0.010	0.373	✓			
R0.338	+/-0.010	0.338	✓			
3.450	+/-0.010	3.448	✓			
Ø0.257	+0.005-0.000	0.258	✓			
R0.375	+/-0.010	0.375	✓			
0.375	+/-0.010	0.375	✓			
R0.032	+/-0.010					
R0.250	+/-0.010	0.250	✓			

Measured by: DTP	Audited by: J.L.	Prototype Approval: N/A
Date: 09/06/16	Date: 09/06/19	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	

